

Work Order ID 129602

February-19-15 9:03:22 AM

129602

Page 1

Item ID: D3488-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blade Fitting RH

Start Date: 2/19/15

Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/06/15

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3488

Rev B

DSK 101

REV D

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg DSK 101 & Folio FA625

2-Deburr

12 SL153-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 SL15-3-10

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Item ID: D3488-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Blade Fitting RH
 Start Date: 2/19/15 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						12	0	15-3-25	Dec
HandFinish	Memo	0.00							
Hand Finishing									
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160						12	0	15-3-26	
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:00 OVEN TEMPERATURE: FINISH TIME: 10:30								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

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Item ID:	D3488-042	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Blade Fitting RH				Stop	*NS2*
Start Date:	2/19/15	Start Qty: 12.00	*12*	Cust Item ID:		
Required Date:	3/06/15	Req'd Qty: 12.00	*12*	Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NB2***

[illegible]

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Item ID: D3488-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade Fitting RH

Start Date: 2/19/15 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/06/15 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS 15-04-23



Picklist Print

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Work Order ID: 129602

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Parent Item: D3488-042

D3488-042

Parent Item Name: Blade Fitting RH

Start Date: 2/19/15

Required Date: 3/06/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No				Each	120.0000		48			
AI S7-1032-225										**			
Insert													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FG				120	1131657	48			
					118520			120					
D6103-003		Manufactured	No				Each	7.0000		12			
D6103-003										**			
Round Billet, Aluminum													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				MAT043				7					
					113646			7					
					129603					12			

DART AEROSPACE LTD		Work Order: 1291002
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number: D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

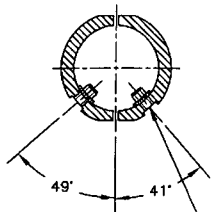
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.151	/		T-G + VERN	
Ø2.780	+/-0.005	2.779	/		mic	SLF
Ø3.125	+/-0.010	3.123	/		mic VERN	
Ø3.346	+/-0.010	3.345	/		-	
0.125 x 45°	+/-0.010 x +/-0.1°	0.125 x 45°	/		-	
8.000	+0.030/-0.000	8.016	/		H-G	
9.250	+/-0.010	9.250	/		H-G	
0.188	+/-0.010	0.188	/		H-G	
R0.032	+/-0.010	0.032	/			
R0.062	+/-0.010	0.062	/			
Ø0.297	+0.005/-0.001	0.299	/			
Ø0.430	+/-0.010	0.432	/			
0.100	+/-0.010	0.102	/			
0.125	+/-0.010	0.132	/		g-pin	
2.620	+/-0.010	2.617	/		VERN	
3.500	+/-0.010	3.500	/		VERN	
1.005	+/-0.010	1.005	/		H-G	
Ø0.484	+0.005/-0.001	0.485	/			
1.180	+/-0.010	1.180	/		VERN	
3.150	+/-0.010	3.150	/		-	
3.070	+/-0.010	3.067	/		H-G	
R0.063	+/-0.010	0.063	/			

DART AEROSPACE LTD		Work Order:	179602
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.509	✓		Gauge	Pin
0.750	+/-0.010	.7485	✓		Height	gauge
1.500	+/-0.010	1.500	✓		"	
11.18	+/-0.030	11.172	✓		"	
R0.062	+/-0.010	.062	✓		Rad Gauge	
0.125	+/-0.010	.120	✓		SLO8	Vern
0.590	+/-0.010	.593	✓		Height	gauge
0.793	+/-0.010	.794	✓		SLO8	
1.351	+/-0.010	1.347	✓		Height	gauge
1.317	+/-0.010	1.320	✓		SLO3	Mic
1.802	+/-0.010	1.796	✓		Height	gauge

Measured by: SL	DAS 20 9-89	Audited by:	DAS 14 9-89	Prototype Approval:	N/A
Date: 15-3-10 / 15-03-22		Date: 15/03/24		Date:	N/A

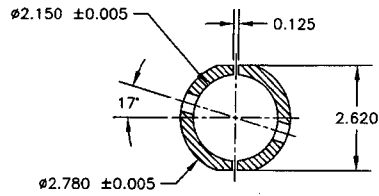
Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)

4



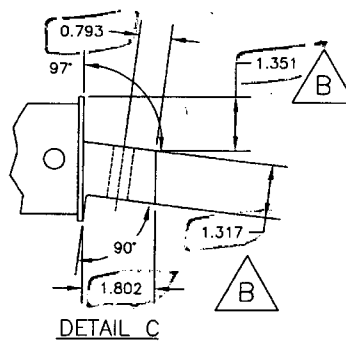
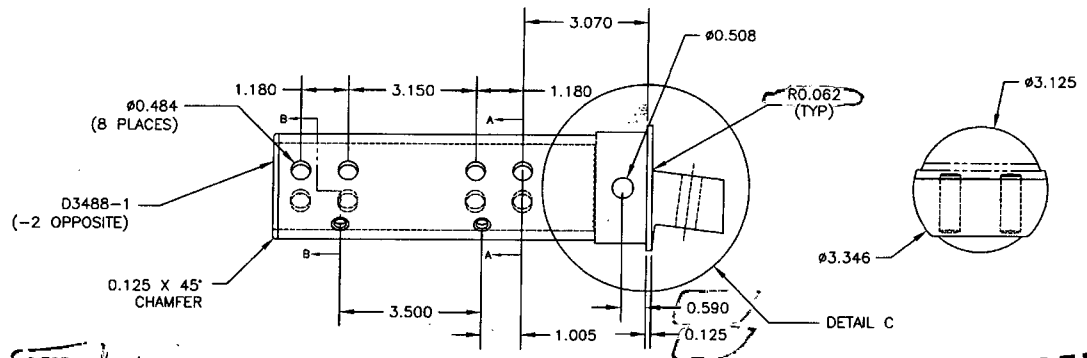
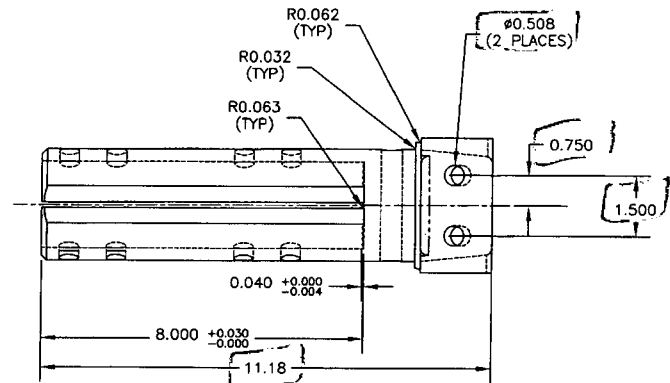
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
PER DS
ICN #739

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	06.03.15	TITLE
		BLADE FITTING
		DART AEROSPACE USA, INC.
		PORT HADLOCK, MA
		DRAWING NO. D3488
		REV. 8
		SHEET 1 OF 1
		SCALE
		1:3

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